






ASAP

Date: Monday, 28/04/2008 8:13:51 AM
User: Julie Lecocq

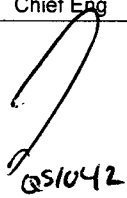
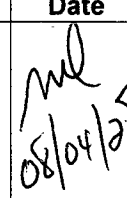
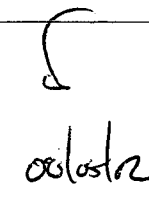
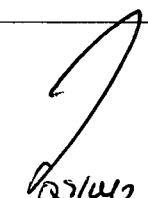
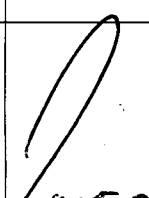
Process Sheet

Customer : CU-DAR001 Dart Helicopters Services		Drawing Name : DOOR ASSEMBLY							
Job Number : 38820									
Estimate Number : 10713									
P.O. Number :		Part Number : D3213041							
This Issue : 28/04/2008 S.O. No. :		Drawing Number : D3213 REV A							
Prsht Rev. : NC		Project Number : N/A							
First Issue : / / Type : SMALL /MED FAB		Drawing Revision : A							
Previous Run : 33121		Material :							
Written By :		Due Date : 05/05/2008 Qty: <i>10</i> Um: Each							
Checked & Approved By : <i>JLD 08.428</i>									
Comment : Est Rev:A New Issue 05-11-17 17:27									
Additional Product									
Job Number: 									
Seq. #:	Machine Or Operation:	Description :							
1.0	D31613	Hinge 15.0"							
									
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s) <i>20</i></p> <p>Pick: Assembly Kit</p> <table border="0" style="width:100%;"> <tr> <td>Qty Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>2 D3161-3</td> <td>Hinge</td> <td><i>B 38832 x 20</i> ✓</td> </tr> </table> <p><i>ml</i></p>				Qty Part Number	Description	Batch	2 D3161-3	Hinge	<i>B 38832 x 20</i> ✓
Qty Part Number	Description	Batch							
2 D3161-3	Hinge	<i>B 38832 x 20</i> ✓							
2.0	D32131	Door Panel							
									
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) <i>10</i></p> <p>Pick: Assembly Kit</p> <table border="0" style="width:100%;"> <tr> <td>Qty Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1 D3213-1</td> <td>Door</td> <td><i>B 38834</i></td> </tr> </table> <p><i>✓ x 10 ml</i></p>				Qty Part Number	Description	Batch	1 D3213-1	Door	<i>B 38834</i>
Qty Part Number	Description	Batch							
1 D3213-1	Door	<i>B 38834</i>							
3.0	D32133	Door Panel							
									
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) <i>10</i></p> <p>Pick: Assembly Kit</p> <table border="0" style="width:100%;"> <tr> <td>Qty Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1 D3213-3</td> <td>Door</td> <td><i>B 38836</i></td> </tr> </table> <p><i>✓ x 10 ml</i></p>				Qty Part Number	Description	Batch	1 D3213-3	Door	<i>B 38836</i>
Qty Part Number	Description	Batch							
1 D3213-3	Door	<i>B 38836</i>							
4.0	MS20470AD44	Rivet, Universal Head							
									
<p>Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s) <i>240</i></p> <p>Pick: Assembly Kit</p> <table border="0" style="width:100%;"> <tr> <td>Qty Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>24 MS20470AD4-4</td> <td>Rivet</td> <td><i>B M 106552</i></td> </tr> </table> <p><i>✓ ml 08/05/01</i></p>				Qty Part Number	Description	Batch	24 MS20470AD4-4	Rivet	<i>B M 106552</i>
Qty Part Number	Description	Batch							
24 MS20470AD4-4	Rivet	<i>B M 106552</i>							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3213-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 08/05/13
 QA: N/C Closed: _____ Date: _____

NCR: 38820		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/28	1	Scrap 1 hinge move during drilling holes	 08/04/28	Scrap and replace by new one Qty 1 B 38832	 08/04/28	 08/04/28	 08/04/28	 0805-02

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:13:51 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 38820

Part Number: D3213041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

x10 P70

ml 08/05/01

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/02 (x10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 8:30am

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00am

08-05-02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10X
08/05/02

9.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2137 Decal

B37068

(9x)

B39139

50

10.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2419 Handle


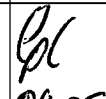


37069

8/5/2

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3213-041 PAR #: N/A Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 01/05/20
 QA: N/C Closed: _____ Date: _____

NCR: <u>38820</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-05-01	5.0	Upon Assembly a 0.040" hole was found below one of the rivet holes on the D3213-3 panel. R.C. water jet malfunction, this is the only part affected.		Fill hole with weld as per QSI 004, and grind flush. Touch-up with Alodine. per QSI 005.	 08-05-01	80 08/05/01	 QSI 0042	 08-05-01

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:13:51 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 38820

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2462

Seal



Comment: Qty.: 2.4000 f(s)/Unit Total: 14.4000 f(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2462

Seal

** 37747*

OTD
scf

12.0

D27281

Dart Logo Label - small



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2728-1

Decal

24215

scf

13.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 AN960JD6 Washer

6085

scf

14.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 MS20470AD4-6

Rivet

107082

8/5/2

10x

scf

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3213

08/05/29
scf sign for monique

16.0

QC5

INSPECT WORK TO CURRENT STEP



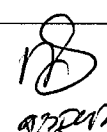


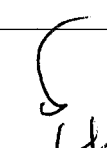


Comment: INSPECT WORK TO CURRENT STEP

5 oct 29 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3213-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: A Date: 08/05/30
 QA: N/C Closed: _____ Date: _____

NCR: <u>38820</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/29	15	1 seal ^{D2462} was not installed incorrectly back of intruss interat.		removed - replace seal D2462 B 37 7 47	SB 08/05/29 Per	 08/05/29		 08/05/29
					MC Monyu Leprae	 08/05/29		 08/05/29

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:13:51 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 38820

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



(10x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 210

8/5/29

sp

18.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/29

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

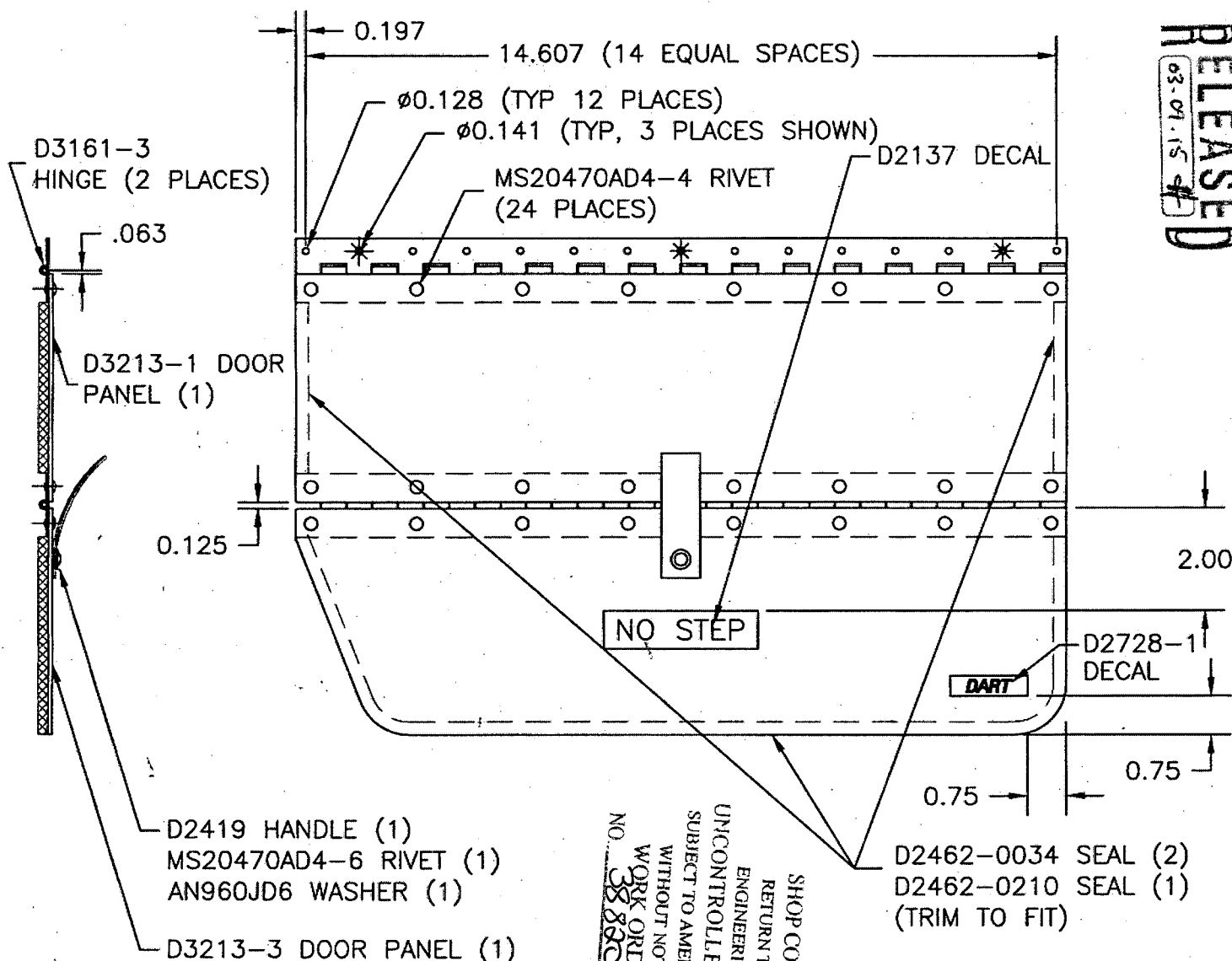
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD
03.09.03	03.09.03	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
03.09.03	03.09.03	D3213
DATE	TITLE	REV. A
03.09.03	DOOR ASSEMBLY	1 OF 2
A	NEW ISSUE	SCALE
		1:3

RELEASED
03-01-15



D3213-041 DOOR ASSEMBLY

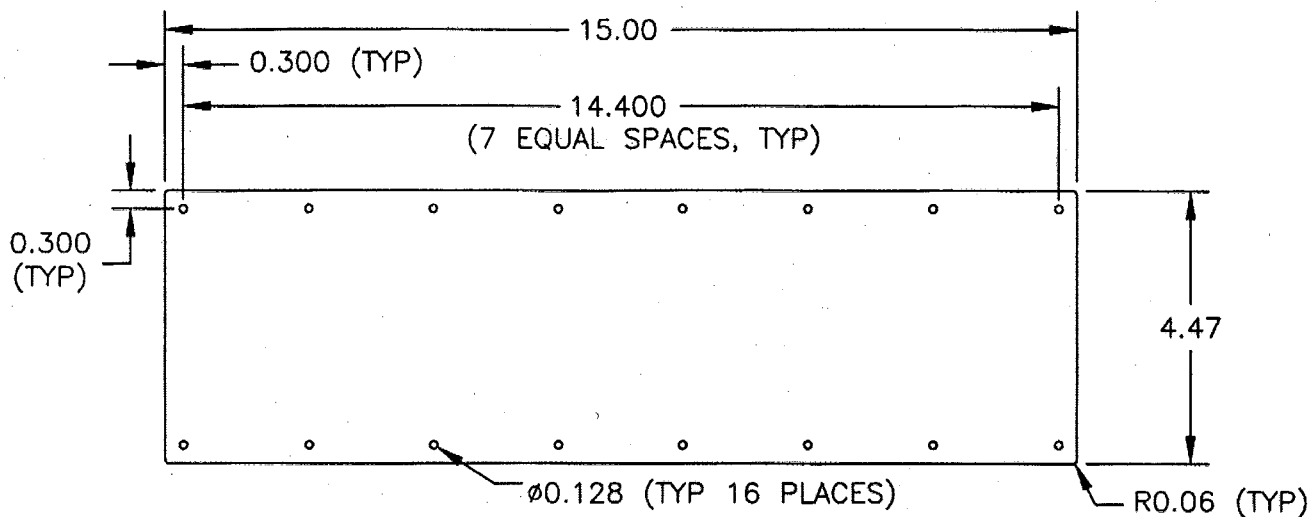
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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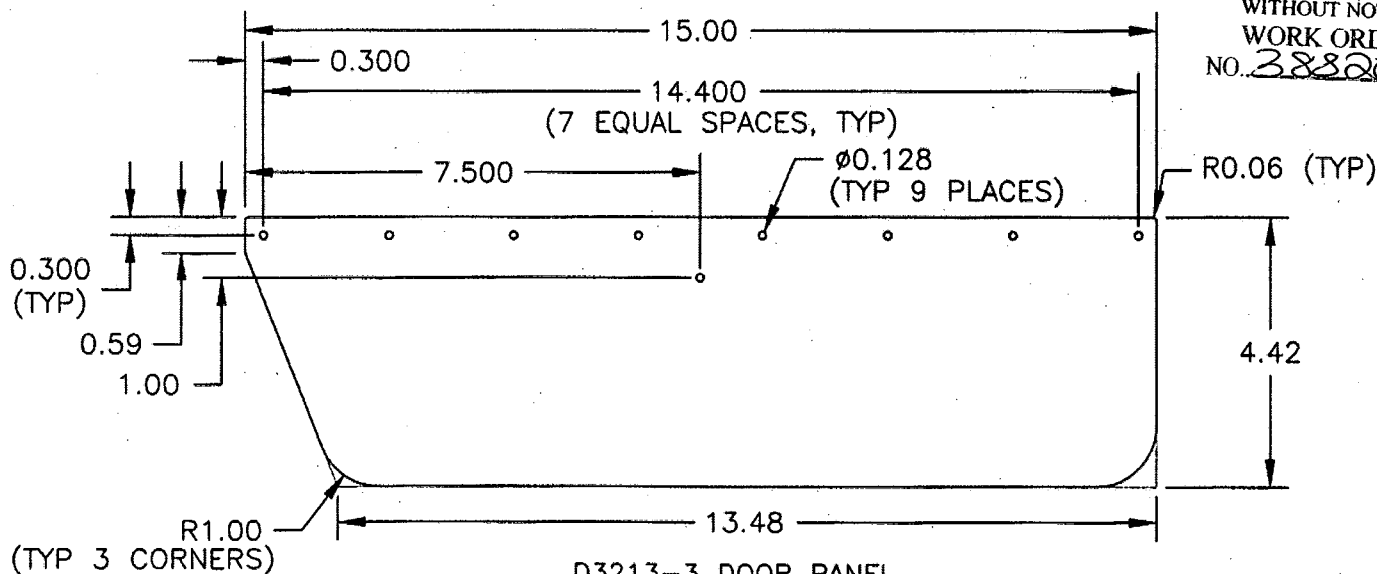


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38820



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.15 *[Signature]*

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